

Date: Thursday, 3/23/2006 3:44:37 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 26350		
Estimate Number	: 10288		
P.O. Number	: N/A	Part Number	: D25771
This Issue	: 3/23/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2577 REV E
First Issue	: N/A	Project Number	: N/A
Previous Run	: 25137	Drawing Revision	: E
	Type : PURCHASED PARTS	Material	: N/A
Written By	: <u>SEE COMMENT BELOW.</u>	Due Date	: 4/15/2006
Checked & Approved By	: <u>06.03.24</u>	Qty:	50 Um: Each
Comment	: Est: E 02.09.24 Re-format; Incorporated D2577-101/-11 KJ/ RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 0000892

Email or Ship DXF file to vendor

Laser Cut per Dwg D2577 flat pattern D2577-101

Material release note required

2.0	D25771F	Wearplate Fwd
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

WEAR PLATE FWD

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material release note is attached

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect dimensions per template D2577-101T

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/23/2006 3:44:37 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 26350

Part Number: D25771

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on brake as per Dwg D2577 using DT8155 and DT8179

2-Form joggle as per Dwg D2577 using DT8157

3-Identify as D2577-1

FF 06.04.20

50

FF 06.04.20

50

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using DT8308A & DT8308B as per Dwg D2577

Qty Description

Batch

A/R 7560 Hardcoat Rod

M100452

H.M 06-04-27

PTD

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION .

06/05/02 (50)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

DL 06/05/03 (50)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 05 03

50

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP 19

DC 06/05/03 (50)

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

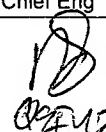
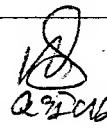
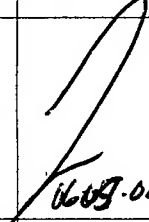
Inspection Level 21

06/05/04 (50)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/05/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-05-02	8	13 warp plates need to be re-melted. Handcast didn't penetrate enough into the warp plate. Lack of heat on the torch.		PASS the torch over the strikers, and re-apply hand cast as necessary. AS per Q51104	M.F. 06.05.02	AA 06/05/02		

NOTE: Date & initial all entries

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

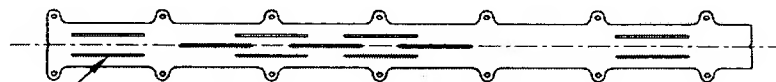
NOTE: Date & initial all entries



RELEASED
00.04.26

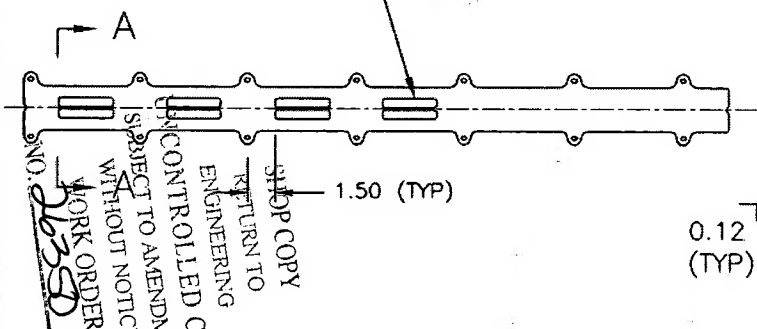
DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. E
CHECKED	APPROVED	DRAWING NO. D2577	SHEET 1 OF 5
DATE 00.09.22	TITLE WEARSHOE	SCALE 1:10	
A	96.09.16	NEW ISSUE	
B	96.12.04	ADD HARDCOAT WELDS	
C	97.05.30	CHANGE HOLES TO OBOUNDS	
D	98.08.17	CORRECTED DIMENSIONS ON -1 & -3	
E	00.09.22	ADD D2577-101/-11/-13 INCORPORATE DE09176	

7560 HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308

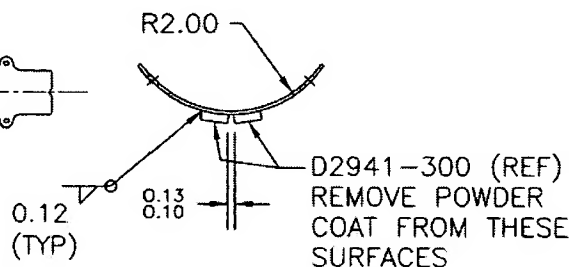


D2577-1 & D2577-3 WEARSHOE
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2941-300
SHWAYDER WEAPADS
(8 PLACES)



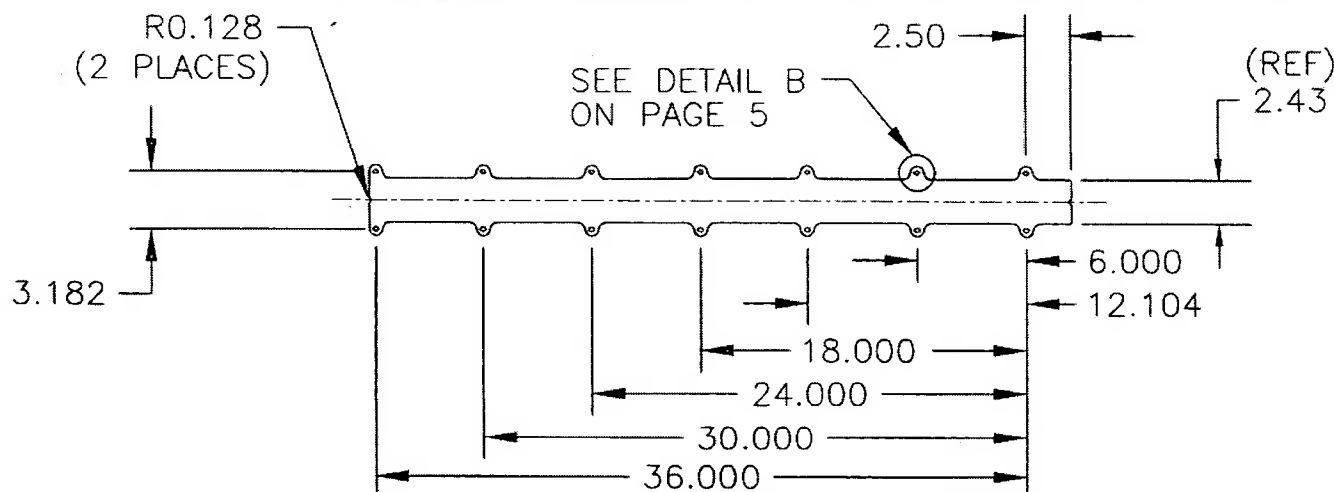
SECTION A-A
SCALE 1:5



D2577-2 & D2577-23 WEARSHOE
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE 00.09.22	TITLE WEARSHOE	REV. E
		SHEET 2 OF 5
		SCALE 1:10



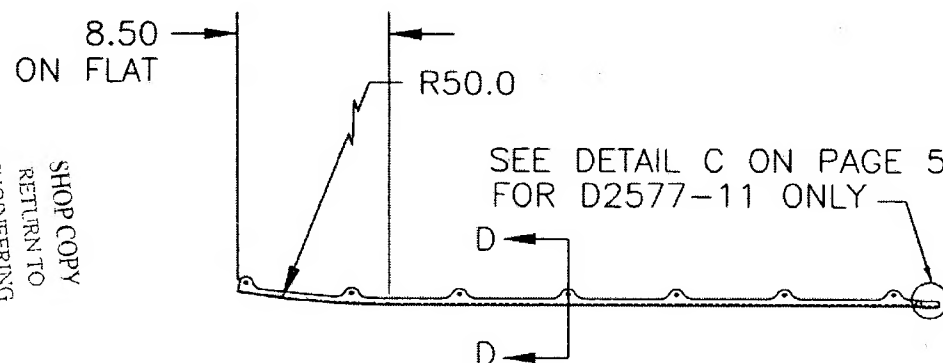
D2577-101 FLAT PATTERN

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2577-11 & D2577-13 LONGITUDINAL BEND

MAKE FROM D2577-101

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
00.09.26

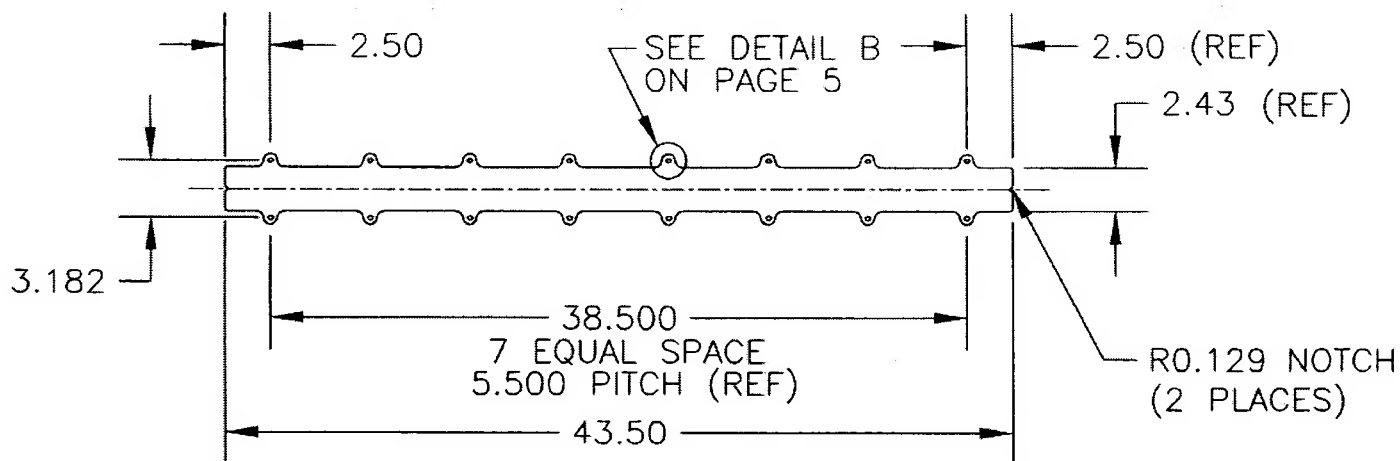
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26350

DART

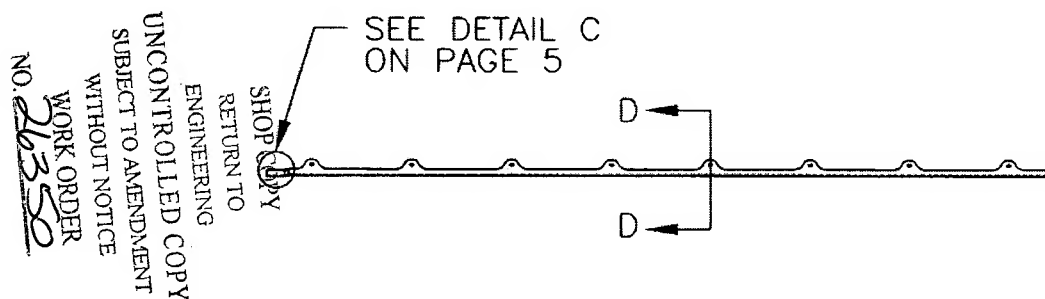


DESIGN	DRWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. E
00.09.22	D2577	SHEET 3 OF 5
	TITLE	SCALE
	WEARSHOE	1:10

D2577-5 FLAT PATTERN



D2577-5 LONGITUDINAL BEND



D2577-5 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
00.09.22

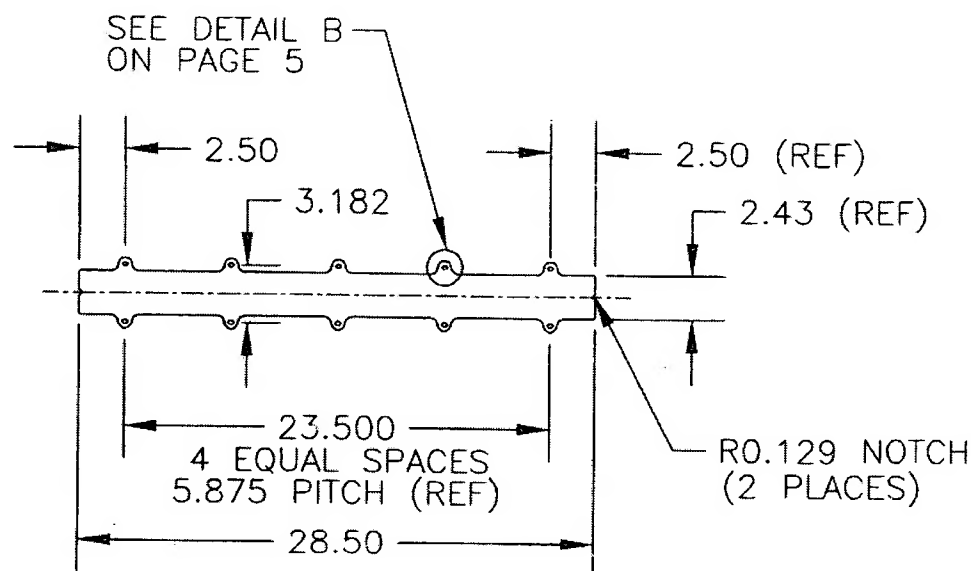
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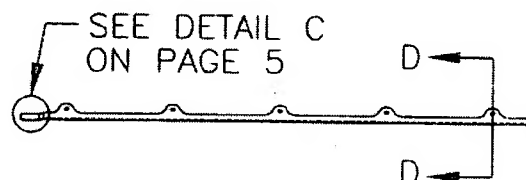
DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2577
DATE 00.09.22		TITLE WEARSHOE
		REV. E SHEET 4 OF 5 SCALE 1:10

RELEASED
00.09.26

D2577-7 FLAT PATTERN



D2577-7 LONGITUDINAL BEND



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WORK ORDER
NO. 26350

D2577-7 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

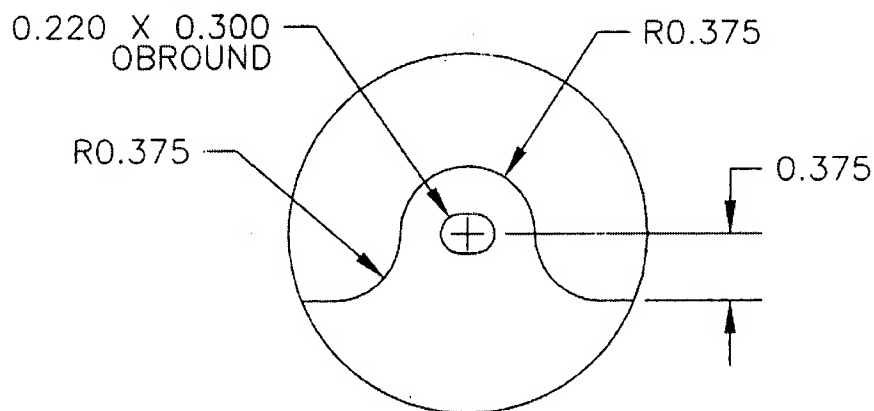
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



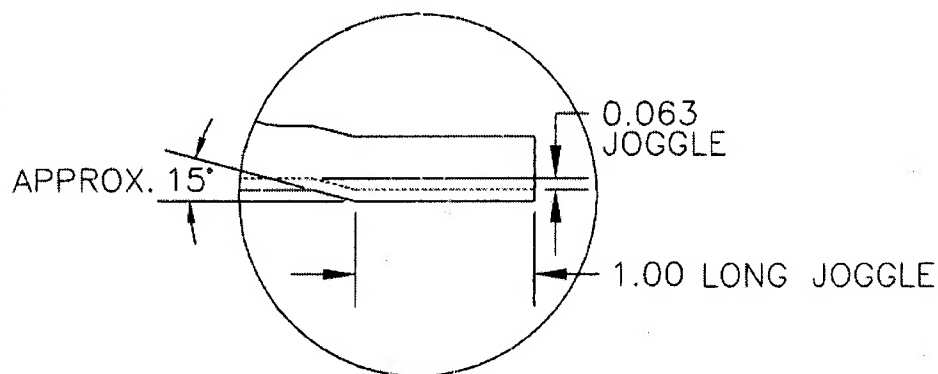
DESIGN #	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2577	REV. E SHEET 5 OF 5
DATE 00.09.22		TITLE WEARSHOE	SCALE 1:10

RELEASED
00.09.26

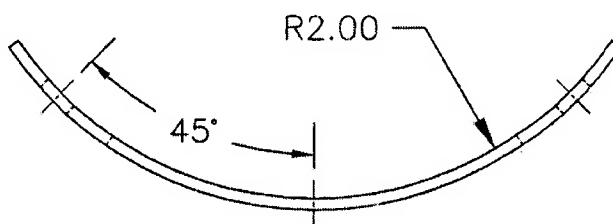
DETAIL B (SCALE 1:1)



DETAIL C (SCALE 1:1)



SECTION D-D (SCALE 1:1)



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B6Q117MD

RESEARCH REPORT

[illegible][illegible]

APPROVED *W. H. H. H.*
DE METALLURGIST

[illegible]



FALL 1991 373

TEST CERTIFICATE

Ref: 530752917

CUSTOMER		Williams		P505050T002		SPECIFICATION		ASTMA1005 CS Type A		CERTIFICATE No		T0115338											
CUSTOMER Q/N		90-284-T42				PRODUCT		CRA WIDE COIL		PAGE		1 of 1											
MILL Q/N		40856				DIMENSIONS		0.031" x 48" x Cold		DATE		02 August 2005											
CHEMICAL COMPOSITION PERCENT																							
PACK NUMBER	HEAT No	C	SI	Mn	P	S	Cr	Ni	Cu	Nb	V	RE	Al	E	H2	CEI	BEND	YIELD	T.S.	ELONG	HARDNESS		LENGTH
		x100					x1000							x1000	x100	180°				CL=	HRB	()	(mm)
R9-464317-00	844863	6	TR	20	7	17	15	23	14	2	0	1	3				Good				45		2015
R9-464318-00	844863	6	TR	20	7	17	15	23	14	2	0	1	3				Good				45		2064
R9-464319-00	779675	6	TR	20	34	16	01	21	13	1	0	1	3				Good				49		2118
R9-464320-00	779675	6	TR	20	14	16	01	21	13	2	0	1	3				Good				49		2225
R9-464821-00	779674	6	TR	24	13	17	13	22	17	2	0	1	3				Good				50		1923
R9-464822-00	779674	6	TR	31	13	17	13	22	17	2	0	1	3				Good				50		1975

YIELD (A) 0.2% PROOF STRESS (B) FLOWER YIELD STRESS	GUAGE LENGTH (G.L.) (A) 200mm (B) 80mm	(C) 2 (D) 8	PLASTIC STRAIN RATIO (r) (A) 0 (B) 50 (C) 10 (D) 60+60+245/14	IMPACT TEST (A) 10mm x 10mm (B) 7.5mm x 10mm	(C) 5mm x 5mm (D) 2.5mm x 10mm (E) 5mm x 10mm	CARBON EQUIVALENT VALUE (CE) (A) C+Mn/6 (B) C+Si+Mn/6+Cr+V+Ni/5+Cu+Ni/15	(C) C+Mn/6+Si/24 (D) =
-----------------------------------------------------------	----------------------------------------------	----------------	---------------------------------------------------------------------------	----------------------------------------------------	-----------------------------------------------------	--------------------------------------------------------------------------------	---------------------------

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION.

APPROVED

Latish Misra
DCMETHANURGE

DCMETH11.07C1

15011700007-3 T M INDUSTRIAL (P5050501002.844863)

04/18/2006 10:46 FAX 604 946 4153

INDUSTRIAL LASER CUTTING → DART

002